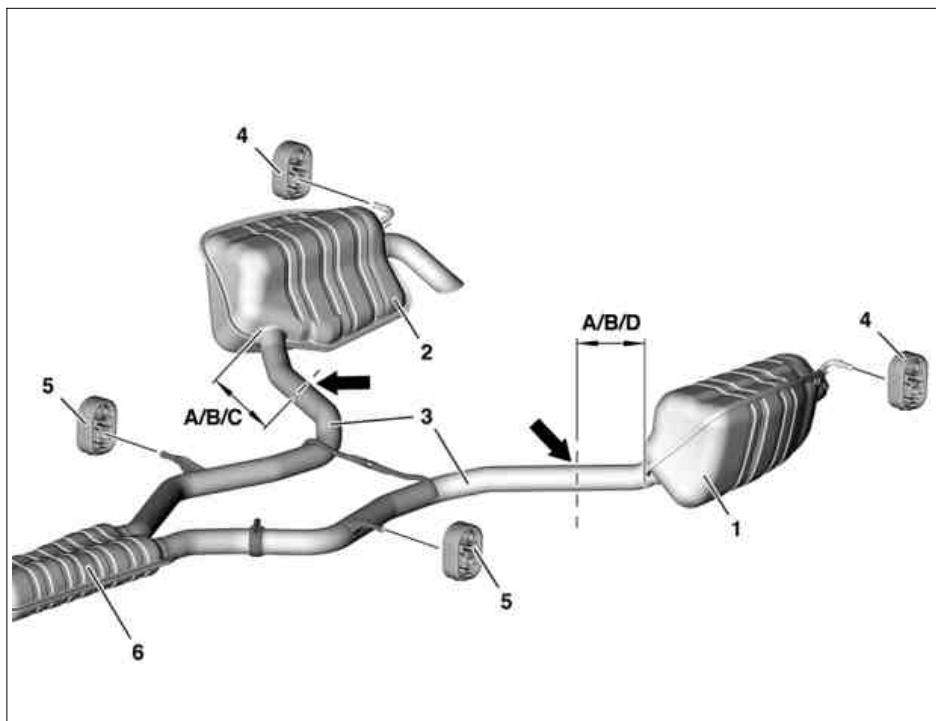


- ENGINE 112.913 in MODEL 211.061 /261
- ENGINE 112.917 in MODEL 211.080 /280
- ENGINE 112.949 in MODEL 211.065 /265
- ENGINE 112.954 in MODEL 211.082 /282
- ENGINE 113.967 in MODEL 211.070 /270
- ENGINE 113.969 in MODEL 211.083 /283
- ENGINE 272.922 in MODEL 211.052 /252
- ENGINE 272.964 in MODEL 211.056 /256
- ENGINE 272.972 in MODEL 211.087 /287
- ENGINE 272.943 in MODEL 211.054 /254
- ENGINE 272.944 in MODEL 211.092 /292
- ENGINE 272.985 in MODEL 211.057 /257
- ENGINE 273.960 in MODEL 211.072 /272
- ENGINE 273.962 in MODEL 211.090 /290
- ENGINE 642.920 in MODEL 211.020 /220 /022 /222 /024
- ENGINE 642.921 in MODEL 211.084 /284 /089 /289
- ENGINE 629.910 in MODEL 211.029
- ENGINE 648.961 in MODEL 211.023 /223 /026 /226

- 1 Left rear muffler
- 2 Right rear muffler
- 3 Exhaust gas pipes
- 4 Exhaust rubber mount (at rear muffler)
- 5 Exhaust rubber mount (at center muffler)
- 6 Center muffler

- A = 155 mm (only engine 112, 113, 272, 273)
- B = 160 mm (only engine 642 /648)
- C = 144 mm (only engine 629)
- D = 97 mm (only engine 629)

i The rear exhaust rubber mounts (4) of left rear muffler (1) and right (2) do no longer exist. They are replaced by the supplied, reinforced exhaust rubber mounts.




P49.10-2678-06

Modification notes

17.3.06	Dimension B for the cut from the rear muffler has changed.	Operation step 3 and legend.	
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	Removing		
1 AR AR AR AR AR	Remove rear muffler	Engine 112, 113. Engine 272, 273. Engine 642. Engine 629. Engine 648.	AR49.10-P-4951TB AR49.10-P-4951TS AR49.10-P-4951TI AR49.10-P-4951TJ AR49.10-P-4951TC
2	Inspect suspension parts, sealing rings and exhaust rubber mounts for reusability	i Replace components if necessary.	

3	Mark exhaust gas pipes (3) of the series exhaust system	<p>i The trimming line (see arrows) at the exhaust gas pipes (3) is measured as of welding seam of left (1) and right (2) rear muffler.</p> <p>Dimension A = 155 mm (only engine 112, 113, 272, 273) B = 160 mm (only engine 642 /648) C = 144 mm (only engine 629) D = 97 mm (only engine 629)</p>	
4	Place AMG rear muffler exactly above removed series rear muffler and mark pipe ends of AMG rear muffler at exhaust pipes (3)	<p>i Important: A distance of approx. 60 mm (overlap) should exist between both markings. If necessary, correct position of separation points accordingly.</p>	
5	Cut off exhaust pipes (3) of the series exhaust system	<p>i Carefully deburr cut edges.</p>	
	Install		
6.1	Attach tailpipe cutout to standard rear apron or AMG rear apron	<p>i Only model 211.0.</p> <p>i For vehicles with code (952) Sport package, cutting the standard rear apron is not possible. Thus, fitting the AMG rear apron of E55 AMG (211.076) with the number B6 603 61 47 is absolutely necessary, whereby in this case, no cutting is required (see note for ordering parts).</p> <p>i For vehicles with code (772) AMG styling package - front spoiler, side skirt and rear apron or code (950) AMG sport package, the new paneling lower section (with a large cutout) must also be ordered. This can be used as an additional template for trimming the AMG rear apron (see "Parts ordering notes").</p> <p>i For vehicles with a standard apron and code (955) Elegance up to code (806) model year 2006, appropriate templates are delivered. From code (807) model year 2007, cutting must be carried out without a template.</p> <p>i Sand down cut edges and paint in the vehicle color.</p> <p>i See: ↓ Retrofit AMG trim parts Model 211.0</p>	AZ88.00-P-0001Q
6.2	Attach tailpipe section to AMG rear apron	<p>i Model 211.2 without code (772) AMG styling package - front spoiler, side skirt and rear apron or without code (950) AMG sport package.</p> <p>i The rear series bumper is not suitable for fitting.</p> <p>i For these vehicles, fitting the AMG rear apron of the E55 AMG (211.276) with the number B6 603 61 54 is necessary (see note for ordering parts).</p> <p>i See: ↓ Retrofit AMG trim parts Model 211.2 except code (550) Trailer hitch</p>	AZ88.00-P-0001Q

6.3	Attach tailpipe section to AMG rear apron	<p>i Only model 211.2 with code (772) AMG styling package - front spoiler, side skirt and rear apron or code (950) AMG sport package.</p> <p>i The old paneling lower section must be removed and the surface must be cleaned for cutting the rear apron. Use the paneling lower section (with a large cutout) as a template before gluing on (pay attention to the model year code, see note for ordering parts).</p> <p>i Sand down cut edges and paint in the vehicle color.</p>	
7	AMG rear muffler preassembled on the standard exhaust system	<p>i Use supplied clamps for this step. For engine M112, insert the delivered reducing bushes.</p>	
8	Install rear muffler	<p>i Install AMG rear muffler with strengthened suspension rings supplied.</p> <p>Engine 112, 113.</p> <p>Engine 272, 273.</p> <p>Engine 642.</p> <p>Engine 629.</p> <p>Engine 648.</p>	<p>AR49.10-P-4951TB</p> <p>AR49.10-P-4951TS</p> <p>AR49.10-P-4951TI</p> <p>AR49.10-P-4951TJ</p> <p>AR49.10-P-4951TC</p>
9	Align and screw down exhaust system	<p>⚙ Ensure that tail pipes are parallel and have adequate clearance to the rear apron.</p>	
10	Check the whole exhaust system for leaks		
11	Hand over supplied EG model approval to the customer	<p>i Approval by the Technical Inspection Association is not necessary in Germany! Carry the EG model approval supplied for AMG muffler system in the vehicle.</p>	

Parts ordering notes

Part no.	Designation	Quantity
B6 603 61 42	The left and right AMG rear mufflers for model 211.052/ 054/ 056/ 057/ 061/ 065/ 070/ 080/ 082/ 083/ 087/ 092 consisting of:	
A211 490 03 01	Left rear muffler	1
A211 490 02 01	Right rear muffler	1
A211 492 00 09	Reducing bush (only for M112 in E240, E320)	2
A203 490 05 41	Clamp 59 mm dia.	2
A211 004 08 99	Cutting template (for standard rear apron; only for code 954 to code 806)	1
A211 004 09 99	Cutting template (for AMG rear apron)	1
A203 492 04 44	Suspension rings	2
A211 008 66 99	EC model approval	1
A211 885 13 25	Panel bottom section up to code 806 (not contained in the parts kit)	1
A211 885 50 25	Panel bottom section from code 807 (not contained in the parts kit)	1
B6 603 20 07	The left and right AMG rear mufflers for model 211.252/ 254/ 256/ 257/ 261/ 265/ 270/ 280/ 282/ 283/ 287/ 292 consisting of:	
A211 490 13 01	Left rear muffler	1
A211 490 14 01	Right rear muffler	1
A211 492 00 09	Reducing bush (only for M112 in E240, E320)	2
A211 490 05 41	Clamp 59 mm dia.	2
A203 492 04 44	Suspension rings	2
A211 000 04 99	EC model approval	1
A211 885 17 25	Paneling bottom section (not included in parts kit)	1
A211 885 20 25	Bottom section paneling with PTS (not included in parts kit)	1
B6 603 20 12	Left and right AMG rear muffler for model 211.020/ 022/ 023/ 026/ 084/ 089 consisting of:	
A211 490 21 01	Left rear muffler	1
A211 490 22 01	Right rear muffler	1
A203 490 05 41	Clamp 59 mm dia.	2
A211 004 08 99	Cutting template (for standard rear apron; only for code 954 to code 806)	1
A211 004 09 99	Cutting template (for AMG rear apron)	1
A203 492 04 44	Suspension rings	2
A211 007 43 99	EC model approval	1
	Only vehicles with code 772 ex factory	
A211 885 13 25	Panel bottom section up to code 806 (not contained in the parts kit)	1

A211 885 50 25	Panel bottom section from code 807 (not contained in the parts kit)	1
B6 603 20 13	Left and right AMG rear muffler for model 211.220/ 222/ 223/ 226/ 284/ 289 consisting of:	
A211 490 23 01	Left rear muffler	1
A211 490 24 01	Right rear muffler	1
A203 490 05 41	Clamp 59 mm dia.	2
A203 492 04 44	Suspension rings	2
A211 007 43 99	EC type approval certificate (until used up)	1
A211 000 39 99	EC model approval	1
	Only vehicles with code 772 ex factory	
A211 885 17 25	Paneling bottom section (not included in parts kit)	1
A211 885 20 25	Bottom section paneling with PTS (not included in parts kit)	1
B6 603 20 14	Left and right AMG-rear mufflers for model 211.029 consisting of:	
A211 490 27 01	Left rear muffler	1
A211 490 28 01	Right rear muffler	1
A211 004 08 99	Cutting template (for standard rear apron; only for code 954 to code 806)	1
A211 490 05 41	Clamp 59 mm dia.	2
A203 492 04 44	Suspension rings	2
A211 007 43 99	EC type approval certificate (until used up)	1
A211 000 39 99	EC model approval	1
	Only vehicles with code 772 ex factory	
A211 885 50 25	Panel bottom section from code 807 (not contained in the parts kit)	1
B6 603 20 19	Left and right AMG rear mufflers for model 211.072/ 090 consisting of:	
A211 490 31 01	Left rear muffler	1
A211 490 32 01	Right rear muffler	1
HWA202 490 03 41	Clamp 64 mm dia.	2
A211 004 09 99	Cutting template (for AMG rear apron)	1
A203 492 04 44	Suspension rings	2
A211 008 66 99	EC model approval	1
	Only vehicles with code 772 ex factory	
A211 885 50 25	Panel bottom section from code 807 (not contained in the parts kit)	1
B6 603 20 20	Left and right AMG rear mufflers for model 211.272/ 290 consisting of:	
A211 490 33 01	Left rear muffler	1
A211 490 34 01	Right rear muffler	1
HWA202 490 03 41	Clamp 64 mm dia.	2
A211 004 09 99	Cutting template (for AMG rear apron)	1
A203 492 04 44	Suspension rings	2
A211 008 66 99	EC model approval	1
	Only vehicles with code 772 ex factory	
A211 885 17 25	Panel bottom section from code 807 (not contained in the parts kit)	1
A211 885 20 25	Paneling lower section with PTS starting from code 807 (not included in parts kit)	1